

Date: Thursday, 6/7/2007 3:34:23 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEB
Job Number	: 32874		
Estimate Number	: 10498		
P.O. Number	: N/A	Part Number	: D2739
This Issue	: 6/7/2007	Drawing Number	: D2739 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: C
Previous Run	: 32655	Material	: N/A
		Due Date	: 6/14/2007
Written By	: _____	Qty:	4 Um: Each
Checked & Approved By	: <u>6/7/06-08</u>		
Comment	: Est Rev: C 02.11.28 Reformat KJ		
	: Est Rev: D 06-03-21 As Per Rev C JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	D26005108	Extrusion 'I Beam' thin
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Comment: Qty: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Extrusion 'I Beam' thin

Pick:

Qty Part Number Description Batch

1 D2600-5 Web

B-29985

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2739.

2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739

3-Use uni-bit to open holes to finish size as per Dwg D2739.

4-Bevel Fwd ends (1" max) of extrusion and Deburr holes and ends.

5-Dburr

07/07/02 ANM

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

07/07/07 ANM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 07/08/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 7-8-7 (4)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock

Location: 46

DP 7-8-7 (4)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

DP 07/08/08 (4)

Job Completion



DP 07-08-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

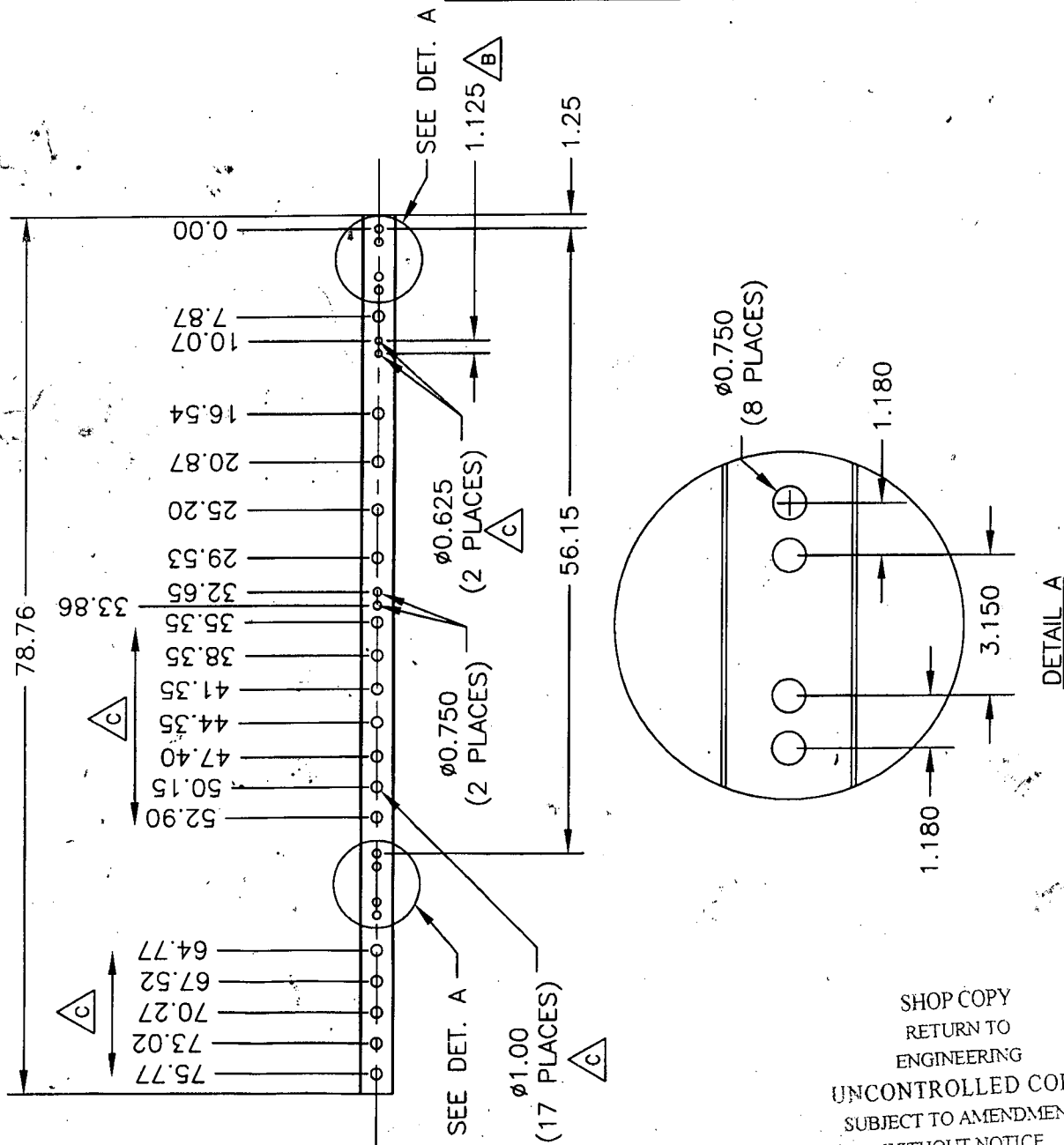
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RH	DRAWN BY RH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2739	REV. C SHEET 1 OF 1
DATE 06.01.05		TITLE WEB	SCALE 1:15
A	98.04.16	NEW ISSUE	
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS	
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS	

RELEASED
06-02-07



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32874

D2739 WEB
1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018, UNLESS OTHERWISE NOTED

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